100132

April-18-13 10:27:34 AM Item ID: 646.3812 Accept *N900040100* Setup Start Revision ID: Item Name: Gusset Bracket **Start Date:** 4/18/13 **Start Qty: 12.00** Cust Item ID: Required Date: 5/02/13 Req'd Qty: 12.00 **Customer:** Reference: Run \ Start Process Plan: 415 Date: 13-04-18 Tooling: Approvals: Date: Stop Date:_____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Code . Qty · Qty Number Stamp Draw Nbr **Revision Nbr** 646.3800 NC 110 -0.00 MJP 13/05/02 *110* HAAS CNC VERTICAL MACHINING #1 HAAS I 0.00 Memo HAAS CNC vertical machine #1 1-Machine per DWG DWG REV: N/C 2- deburr and break all sharp edges JUSP 13/05/02 120 QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

Work Order ID 100132

120

Quality Control

QC

NCR: Y	'es / 1	No			WORK ORDER NON-	CON	IFORN	AANCE / UPD	ATE	QA Closed:	Date	:
Work Orde	er:				DISPOSITION			,	AGAINST DE	PARTMENT/	PROCESS	[*] **
Part N	-				 Rework Scrap Use-as-is		! Therm	Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
NCR N	lo				 Work Order Update	╛╏		Large Fab	Composite]	Supplier [_	
Root Cause	Da	te	Step	Qty	ption of work order update or Non-conformance		nitial ef Eng	Actio Descri		Şign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
опорриотеся			·		 F	AUL	T CATE	GORY				
Landin	Crack Crush Cuffs Heat Inspe Rippl	re Notes red/Contract ction es in large	rimped. Strip in Bend	extrusion	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instruct Mainte Mislabe Misread Offset Out of O	on Incomplete ions Incomplete/Ui nance led	nclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio



* ...

DQA: Date:

Work Order ID 100132

April-18-13 10 Item ID: Revision ID: Item Name:	:27:34 AM 646.3812 Gusset Bracke	it	VU	Accept	132* *N900	1 040	100	ገ*	Setup Star Stop	I VI	Page 2 S1* S2*
Start Date: Required Date: Reference:	4/18/13 : 5/02/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item Customer					IV	
Approvals:	Process Pla	n:	Date:	Tooling:	I	Date:			Run Star	1/7	R1*
	QC:		Date:	SPC (Y/N):	I	Date:			Stop	` *N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*130 *130* QC Quality Control		QC8- Inspect parts - secon	nd check	0.00				12			الم الم
140 *140* Outsource4 Outsource process -	Anodize	Outsource process-Anodiz Memo Issue P/O: Black Anodiz		0.00						13-04	1-6
150 *150* Packaging Packaging		Receive & Inspect for Dan	nage & Mat'l Certs	0.00				— <i>(</i>	[48/c	//2	

NCR:	Yes	/ No				WORK ORDER NON-C	COL	VFORM	/IANCE / UPI	DATE		D-1-	
											QA Closed:	Date	
144I. OI						DISPOSITION	1			AGAINST D	EPARTMENT	/PROCESS	
Work Ord	er:					Rework	1		Skid-tube	Crosstube	\neg	Water Jet	Engineering
Part I	Viα					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
, are t	•••					Use-as-is	1		noforming	Finishing		re/Packaging	Other
NCR I	No.					Work Order Update]		Large Fab	Composite]	Supplier	
											Ticheo	<u></u>	
Root					1	ption of work order update	1	Initial		tion	Sign &	 Verification	QC Inspector
Cause		Date	Step	Qty		or Non-conformance	Cn	nief Eng	Descr	ription	Date	vernication	QC Inspector
Doc/Data	<u> </u>								:				
Equip/Tooling	\vdash								ı				
Operator	Н								í]		
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Setup	H												
Other Process		ł			-				l				
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		Bending				Bend		Grain			Ovalized		Pressure/Forced
	L	Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	·	Temperature/Cure
		Cracks				Broken/Damaged	_	a '	on Incomplete	<u> </u>	Part Incorre	<u> -</u>	Weld
		Crushed/	Crimped	-	<u> </u>	Burrs	<u>_</u>	-	ions Incomplete/l	Unclear	Part Lost/M		Wrong Stock Pulled
		Cuffs				Contamination	L	Mainte		<u> </u>	Part Moved		
		Heat Trea	it .		<u> </u>	Countersink	\perp	Mislabe			Positioned \		1
		Inspectio	n Strip in	Tube		Cut Too Short	_	Misread	l	L	Power Loss,	'Surge [Other ·
		Ripples in	Bend			Drill Holes		Offset			·		
		Torque M	laves in F	vtrusio	n [Drawing	1	Out of C	Calibration	ور			

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

Work Order ID 100132 April-18-13 10:27:34 AM Item ID: 646.3812 Accept **Revision ID:** Item Name: Gusset Bracket **Start Date:** 4/18/13 **Start Qty: 12.00** Required Date: 5/02/13 Req'd Qty: 12.00 Reference: Process Plan: Approvals: Date: _____ Tooling: Date: Sequence ID/ Operation Work Center ID Description 155 QC5- Inspect part completeness to step on W/O *155* OC Memo Quality Control

N900040100

Setup Start

CL 13/06/12

Cust Item ID:

Customer:

Run Date: Stop SPC (Y/N): Date:

Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. **Run Hours** Code Qty Qty Number Stamp 0.00

160

Spray Painting per QSI005 4.2

0.00

160 SprayPaint

Spray Painting

Memo

0.00

PRIME AS PER DWG, SEE NOTE #2

125452 CARDINAL 4860-50 PRIMER BATCH:

170

QGIA-Inspect Spray Paint



170

Quality Control

Memo

NCR:	Yes	1	No

DQA: _____ Date: ___

NCR:	Yes	/ No				WORK ORDER NON-	COI	VFORI	MANCE / UP	DATE			
											QA Closed:	Date	
Nork Ord	er:					DISPOSITION				AGAINST DI	EPARTMENT,	/PROCESS	
					***	Rework	7		Skid-tube	Crosstube	7	Water Jet	Engineering
Part	No.					Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	e/Packaging	Other
NCR	No.					Work Order Update			Large Fab	Composite		Supplier	
Root					Descr	iption of work order update	T	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data													·
quip/Tooling													
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							FAUL	T CATE	GORY				
Land		7			_	General	_	7			٦	r	-
		Bending			L	Bend	<u> </u>	Grain		<u> </u>	Ovalized	<u> </u>	Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route	_	Hardwa			Over/Under	├	Temperature/Cure
		Cracks			<u></u>	Broken/Damaged	L	4 '	on Incomplete	_	Part Incorre	ļ	Weld
		Crushed/	Crimped.			Burrs	<u>_</u>	4	ions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs			_	Contamination		Mainte		_	Part Moved		
		Heat Trea	it			Countersink		Mislabe			Positioned V		_
		Inspection	n Strip in	Tube		Cut Too Short		Misread	t	_	Power Loss/	Surge	Other
		Ripples in	Bend		L	Drill Holes		Offset					· · · · · · · · · · · · · · · · · · ·
		Torque W	aves in E	xtrusio	n [Drawing		Out of 0	Calibration				
		Turning S	equence			Finish		Out of	Sequence				
		M/ayo/Tw	ict in Tuk	20		Teolio	[Outside	Dimensions				•

Quality Control

Page 4 April-18-13 10:27:34 AM Item ID: 646.3812 Accept *N900040100* Setup Start **Revision 1D:** Item Name: Gusset Bracket **Start Date:** 4/18/13 **Start Qty: 12.00** Cust Item ID: Required Date: 5/02/13 Req'd Qty: 12.00 **Customer:** Reference: Run Process Plan: Date: **Approvals:** Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Number Stamp Identify as per dwg & Stock Location: よナガる 180 *180* Packaging 0.00 Memo Packaging ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV*** 190 QC21- Final Inspection - Work Order Release 0.00 *100* QC 0.00 Memo

U1306.17

										DQA:	Date	:
NCR: \	res / No				WORK ORDER NON-O	CON	NFORN	/IANCE / UP	DATE	QA Closed:	Date	::
		·			DISPOSITION			6630	AGAINST DE	2.000 2.000	/PROCESS	
Part N	lo				Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite				Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		1		Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved					F	A UI	T CATE	GORY				
Landii	ng Gear				General	701	CATE	30111				
	Bending Centre N Cracks Crushed, Cuffs Heat Tre	on Strip in		D/S	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes			on Incomplete ions Incomplete/ nance led	'Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Vaves in E	Extrusior	, [Drawing		Out of C	Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-18-13 10:27:38 AM

Work Order ID: 100132

100132

Parent Item:

646.3812

646 3812

Parent Item Name: Gusset Bracket

Start Date: 4/18/13

Required Date: 5/02/13

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED:DD

_	· ·					4.00						_		
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
M7075T6A0.75X0.75X 0.060X0.060		Purchased	No		- 		f	0.0000		1.263158			· - i- -	+

*M7075T6A0 75X0 75X0 060X0

7075T6 ANGLE .75" X .75" X .060" X .062"W

**

NO MATE IN THE COMPUTER. NOT REMOVE.

											DQA:	Date	
NCR:	Yes	/ No				WORK ORDER NON-C	10:	NFORM	MANCE / UP	DATE	QA Closed:	 Date	
Mark Ord		•		77	•**	DISPOSITION				AGAINST DE		Tan 127 7	
Work Ord Part I	- . No.					Rework Scrap Use-as-is Work Order Update		Thermoforming Finishing		Small Fab		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root	П	. '			Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved							A 1 5 1	T CATE	CORV				
1 4							401	T CATE	GURT				
Landi		ear Bending Centre No Cracks Crushed/i Cuffs Heat Trea Inspection Ripples in	Crimped It n Strip in Bend	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/ enance eled	'Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	1	Torque W	aves in t	xtrusio	n	Diaming	i	logr of c	-alibration				

Out of Sequence

Outside Dimensions

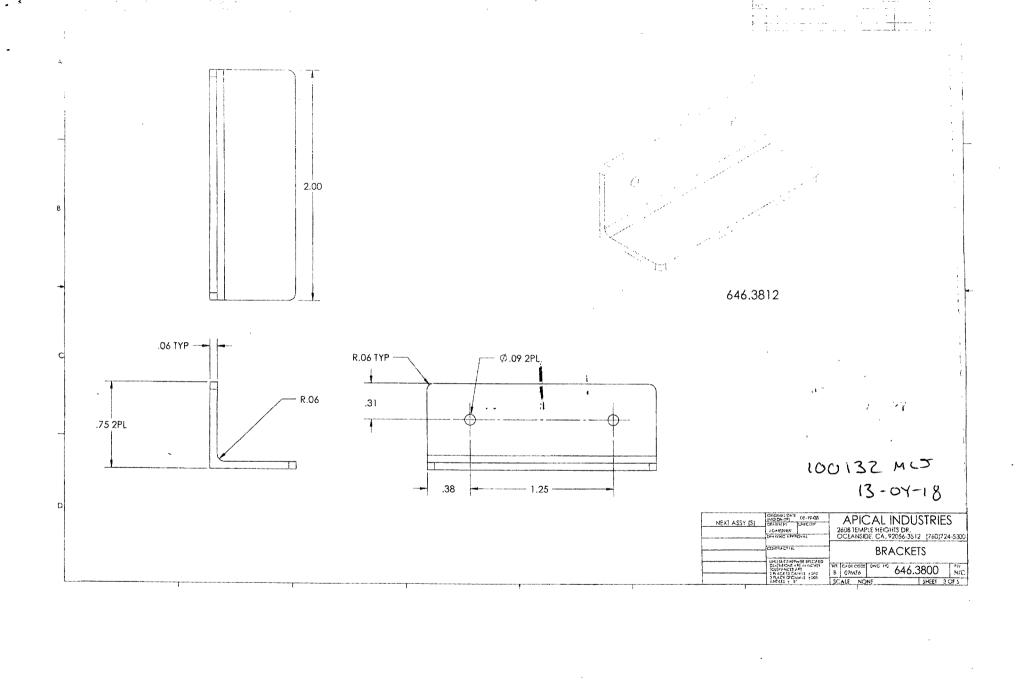
Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



DART AEROSPACE LTD	Work Order:	100 132
Description: Gusset Brackect	Part Number:	646,3812
Inspection Dwg: 646, 3800 Rev: N/C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2,000	= 0,010	2,001	V		MJP-04	vern
0,75	-0.010	0,749	V		111	///
0,06	7 0,010	0,063	/		711	, 11
0,090	+ 0,004	0,090	/		111	111
0,31	+ 0,005	0,307			111	111
0,38	+ 0,000	0,381	/		111	(1)
1,25	= 0,000	1,253	_/_		. / ١ ٩	(1)
R 0,06	+ 0,010	0,060	_ V			Ladius Gage
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	1					

Measured by:	MAJONA	Audited by:	Sh	Preliminary Approval:	
Date:	13/05/02	Date:	13-4-3	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

1 10.04.15

ul.

H:\FORMS\Quality Assurance\approved QA\FAI revE



A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 62441

Date: 12-Jun-13

To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Cuantity Description Rev:				111. 013-032-3200	Fax: 013-032-1105	
10 Part: 646,3311 Rev: HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N Job: 20130360 PO: 19997 Line: 10 Part: 646,3210 Rev: HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIMER PER MIL-P-23377J TYPE I CLASS N Job: 20130359 PO: 20099 Line: 1 Part: ASST Rev: 10 PCS 646,3715 12 PCS 649,3812 HARD ANODIZE BLACK MIL-A-8025 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N Job: 20130358 PO: 20113 Line:	erms		Ship Via			
10 Part: 646.3311 Rev: HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N Job: 20130360 PO: 19997 Line: 10 Part: 646.3210 Rev: HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIMER PER MIL-P-23377J TYPE I CLASS N Job: 20130359 PO: 20099 Line: 1 Part: ASST Rev: 10 PCS 646.3715 12 PCS 646.3812 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N Job: 20130356 PO: 20113 Line:		Т.				
ea HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N Job: 20130360 PO: 19997 Line: 10 Part: 646.3210 Rev: HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIMER PER MIL-P-23377J TYPE I CLASS N Job: 20130359 PO: 20099 Line: 1 Part: ASST Rev: 10 PCS 646.3715 12 PCS 648.3812 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N Job: 20130358 PO: 20113 Line:	Quantity	Description				
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Job: 20130360 PO: 19997 Line: 10	ea	HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2				
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HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIMER PER MIL-P-23377J TYPE I CLASS N Job: 20130359 PO: 20099 Line: Part: ASST Rev: 10 PCS 646.3715 12 PCS 649.3812 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N Job: 20130358 PO: 20113 Line:				Rev:		
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12 PCS 648:3812 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N Job: 20130358 PO: 20113 Line:				Rev:		
MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N Job: 20130358 PO: 20113 Line:		10 PCS 646.3715 12 PCS 648.3812				
Job: 20130358 PO: 20113 Line:						
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Certificate of Conformance			1 0.20110	LINE.		
Certificate of Conformance	,					
Certificate of Conformance						
Certificate of Conformance			,			
Softmonte of Comornance		Certificate of Co	nformance			



A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 62441

Date: 12-Jun-13

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Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via				
Quantity	Description					
Quantity	A.T.G. Industries certifies that all items in with all requirements, specifications and ISO 9001: 2008 REG ATG SALES-2010 TEIDATE: 12/6//3 CERTIFIED SIGNATURE: RECEIVER SIGNATURE:	orawings referenced in the purchase order. GISTERED				
		•				